

Date: Monday, 6/5/2006 7:46:45 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (19"X24")
 Job Number : 27357
 Estimate Number : 10323
 P.O. Number : NIA Part Number : K10008
 This Issue : 6/5/2006 S.O. No. : NIA Drawing Number : D2432 REV F3
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : F3
 Previous Run : 26661 Material : NIA
 Written By : *See comment below* Due Date : 6/24/2006 Qty: 10 Um: Each
 Checked & Approved By : *06.06.05*
 Comment : Est Rev. 04.02.17 Blank size changed KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile:
 K10008
 D206-559-013
 D350-578-011
 D427-659-011
 D315-670-011
 and create labels per PPP K10008
 CHG006(Bag Bluefiles separately)

KS 06.02.06

2.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 6.8250 sf(s)/Unit Total : 68.2500 sf(s)
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: *M100501*

J.F. 06/06/18

10



3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

J.F. 06/06/18

10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:46:45 AM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/06/18

10

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 06/06/21

10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

7.0

D2182B050

Rubber Cushion



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

B24870 ✓

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274

Radius Block

2 D2432F(ref only)

Bearpaw

B26078 3mco ✓
B26500 117mco ✓
B27357 ✓

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438

Clamp

B25611 ✓

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 27357

Part Number: K10008

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	D2529	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer B26485 ✓

11.0	D2732050	Rubber Cushion
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion B26972 ✓

12.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt M19085 ✓

13.0	AN417A	Bolt
------	--------	------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M19471 ✓

14.0	AN960JD416	Washer
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M100575 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 06/06/23

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:46:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 27357

Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M19085 ✓

P 6/6/21

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AL 06/06/22 (10)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location: _____

REV E

P 6/6/22 (10)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/23 (10)

Job Completion



U 06-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27357
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063 x 45°	✓			
B	5.500	+/-0.030	5.500"	✓			
C	0.200	+/-0.030	.1985"	✓			
D	0.25 x 45°	+/-0.030	.240 x 45°	✓			
E	R0.250	+/-0.030	R0.250"	✓			
F	0.250	+/-0.010	.253"	✓			
G	0.625	+/-0.030	.630"	✓			
H	0.375	+/-0.010	.378"	✓			
I	0.950	+0.030/0.010	.952"	✓			
J	19.000	+/-0.030	19.000"	✓			
K	3.14	+/-0.030	3.120"	✓			
L	3.28	+/-0.030	3.310"	✓			
M	Ø0.260	+0.005/-0.000	Ø.260"	✓			
N	Ø0.93	+/-0.030	Ø.930"	✓			
O	0.30	+0.030/-0.000	.315"	✓			
P	23.750	+/-0.030	23.750"	✓			
Q	7.375	+/-0.030	7.377"	✓			
R	4.250	+/-0.010	4.254"	✓			
S	2.000	+/-0.030	1.995"	✓			
T	9.000	+/-0.010	9.005"	✓			
U	9.000	+/-0.010	9.000"	✓			
V	0.375	+/-0.010	.385"	✓			

Inspected
06-06-18
Do not
change

Measured by: J.F.	Audited by: BG	Prototype Approval:	N/A
Date: 06/06/18	Date: 06.06.18	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RR	TF



DESIGN KE		DRAWN BY KE		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MA		APPROVED JS		DRAWING NO. D2432	
DATE 98.05.12		TITLE BEARPAW		REV. F SHEET 1 OF 2	
A	95.10.31	NEW ISSUE			
B	96.01.24	RE-DESIGN			
C	96.03.26	CHANGE BORE AND C'BORE DEPTH			
D	96.06.04	MOVE SLOT			
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS			
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N			

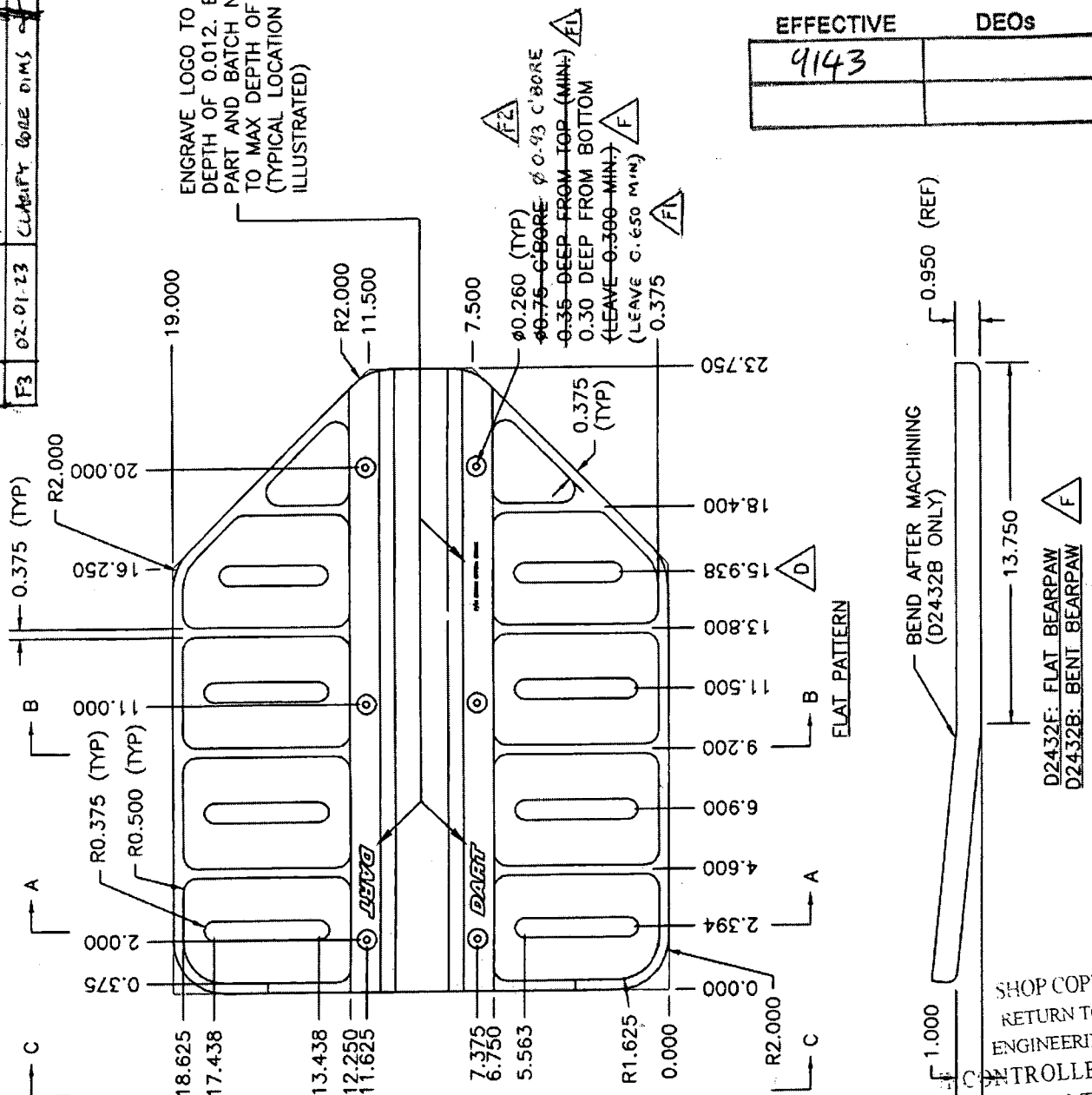
RELEASED
98.06.17 KE

F1	99-03-03	ADD DEC 9143	
F2	01-03-28	Ø 0.93 WAS Ø 0.75	RF
F3	02-01-23	CLARIFY CODE DMS	RF

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

EFFECTIVE DEOs

9143



D2432F: FLAT BEARPAW
D2432B: RENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
JECT TO AMENDMENT

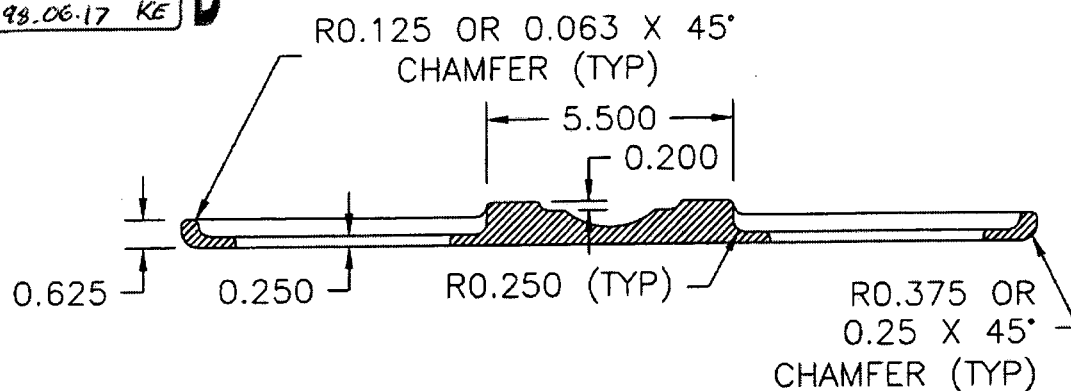
WORK ORDER
3725

NO. 21351

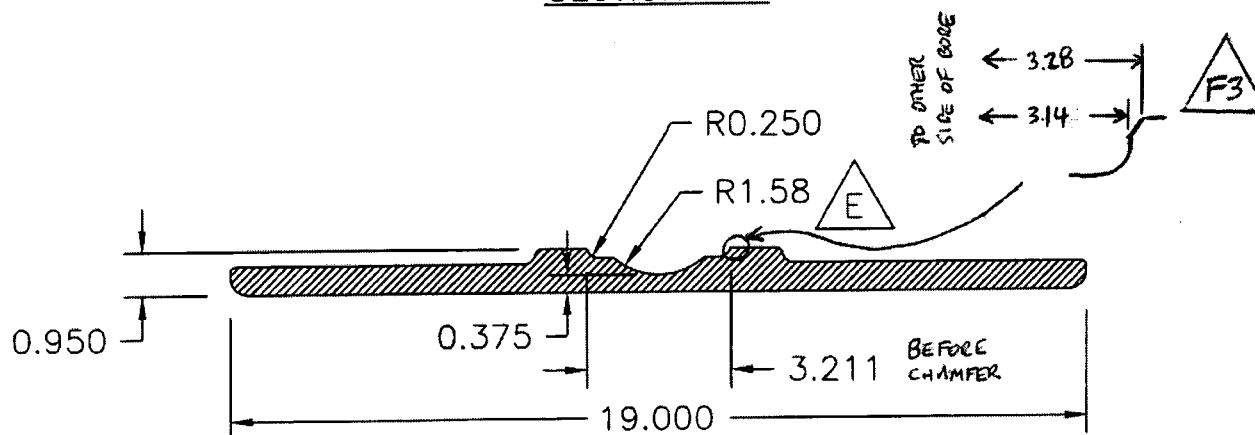


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MK	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

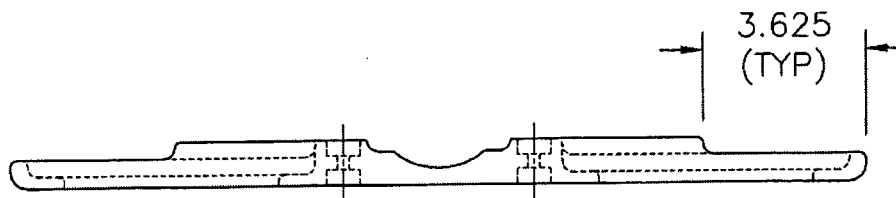
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21351